



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68209**

Friday, April 08, 2011 11:49:21 AM

Page 2

Item ID: D3574-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Cabin Floor Protector

Start Date: 4/8/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

*LP* 04/04/13 (2)

*ML* 11 04 13 (2)

11/4/14 (2) *S*

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Page 3

Item ID: D3574-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/4/18   
MF  
11-04-15

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# Picklist Print

Friday, April 08, 2011 11:49:28 AM

Page 1

Work Order ID: 68209



Parent Item: D3574-5



Parent Item Name: Cabin Floor Protector

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,844.715		67.23362			
GE PLASTICS LEXAN SHEET													



B11-4-13

Location

Loc Qty

Loc Code

MAT018

2844.715789

112585

56

115261

768

116236

2020.71579

115261

②

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	48209
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-5
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	x		V B02	
7.37	+/-0.030	7.37	o		T B01	
11.00	+/-0.030	11.00	x		T	
15.25	+/-0.030	15.25	x		T	
25.87	+/-0.030	25.87	x		T	
39.75	+/-0.030	39.75	x		T	
44.75	+/-0.030	44.75	x		T	
49.11	+/-0.030	49.11	x		T	
51.11	+/-0.030	51.11	x		T	
1.75	+/-0.030	1.75	x		T	
58.38	+/-0.030	58.38	x		T	
63.50	+/-0.030	63.50	o		T	
65.25	+/-0.030	65.25	o		T	
11.87	+/-0.030	11.87	o		T	
14.75	+/-0.030	14.75	x		T	
26.00	+/-0.030	26.00	o		T	
40.87	+/-0.030	40.87	o		T	
45.00	+/-0.030	45.00	o		T	
48.00	+/-0.030	48.00	x		T	
55.13	+/-0.030	55.13	o		T	
58.38	+/-0.030	58.38	o		T	
61.25	+/-0.030	61.25	o		T	
61.88	+/-0.030	61.88	o		T	
64.63	+/-0.030	64.63	o		T	
7.63	+/-0.030	7.63	o		T	
11.00	+/-0.030	11.00	o		T	
22.50	+/-0.030	22.50	x		T	
35.13	+/-0.030	35.13	o		T	
36.50	+/-0.030	36.50	o		T	
40.00	+/-0.030	40.00	x		T	
41.88	+/-0.030	41.88	o		T	
43.63	+/-0.030	43.63	x		T	
6.75	+/-0.030	6.75	o		T	

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68209
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-5
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.55	X		T HB01	
10.38	+/-0.030	10.38	X		T	
14.50	+/-0.030	14.50	X		T	
16.75	+/-0.030	16.75	X		T	
19.00	+/-0.030	19.00	X		T	
24.13	+/-0.030	24.13	X		T	
33.88	+/-0.030	33.88	X		T	
39.50	+/-0.030	39.50	X		T	
40.25	+/-0.030	40.25	X		T	
43.50	+/-0.030	43.50	X		T	
43.83	+/-0.030	43.83	X		T	
46.60	+/-0.030	46.60	X		T	
0.125	+/-0.010	0.130	2		V HB02	

<b>Measured by:</b> RB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-4-13	<b>Date:</b> 11-04-13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	[Signature]

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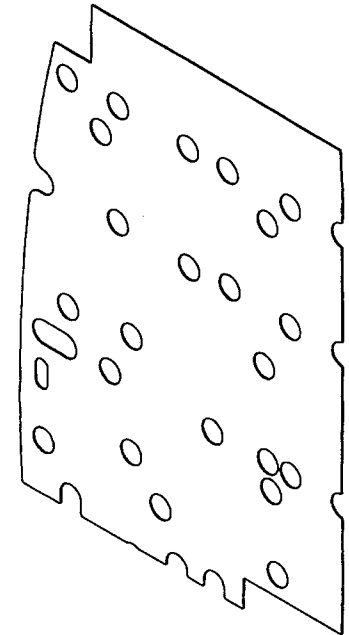
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SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68209

*M1104-8*



RELEASED  
09/04/07

**D3574-1 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXX.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-S; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
DE APPR.		
DATE	09.03.25	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. D3574		
TITLE CABIN FLOOR PROTECTOR		
SCALE NTS		
REV. B SHEET 1 OF 6		
COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

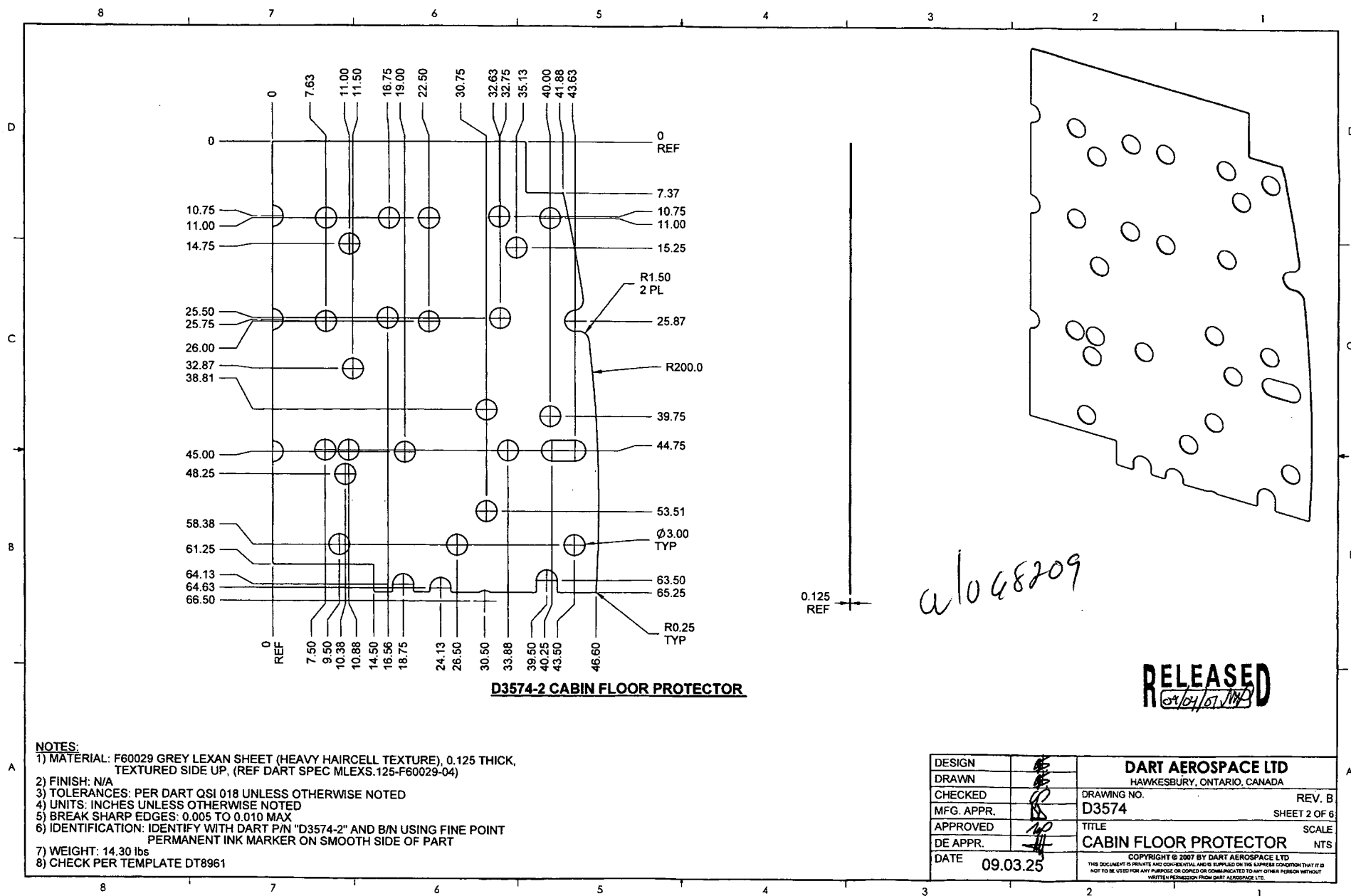
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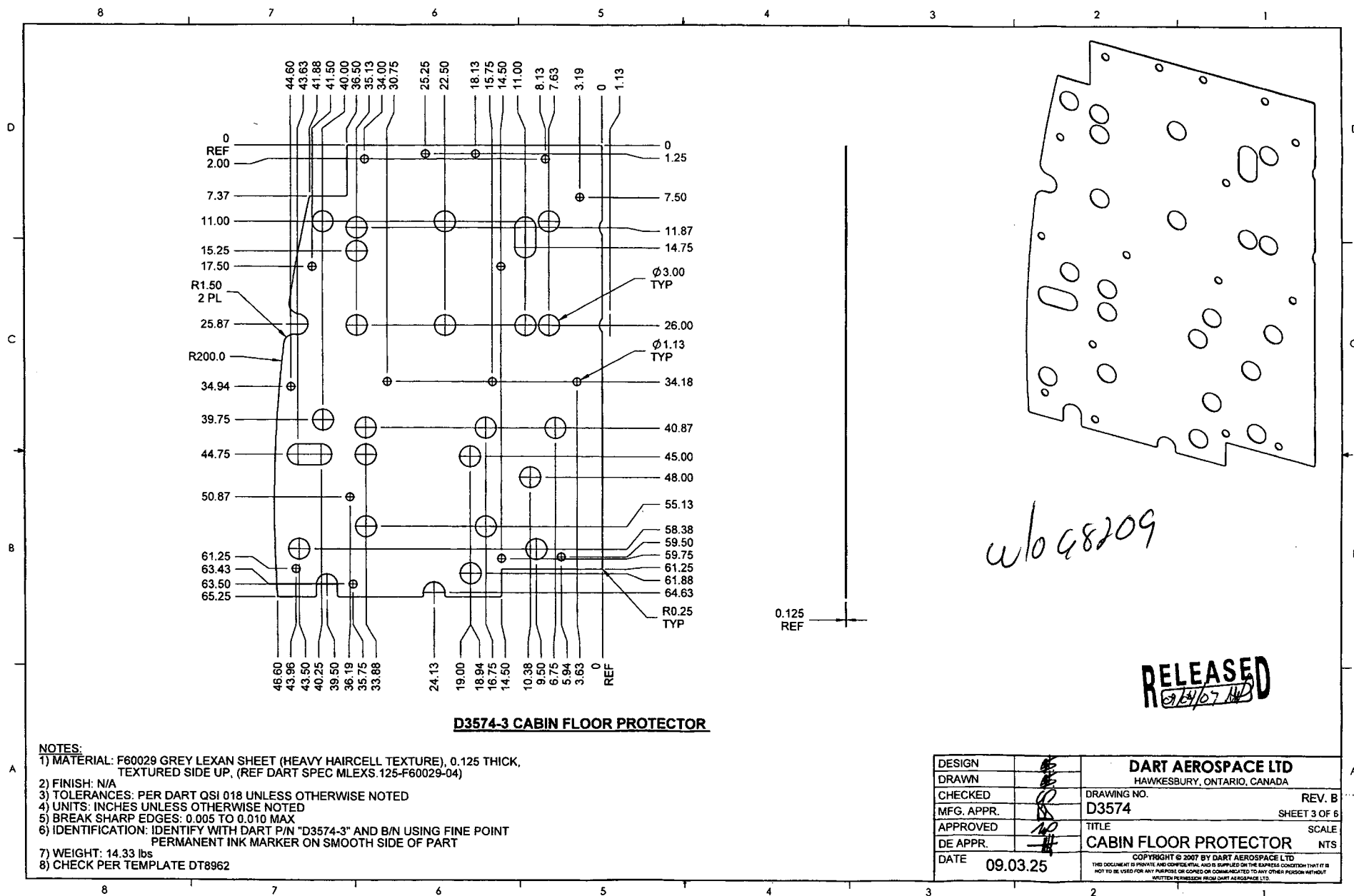
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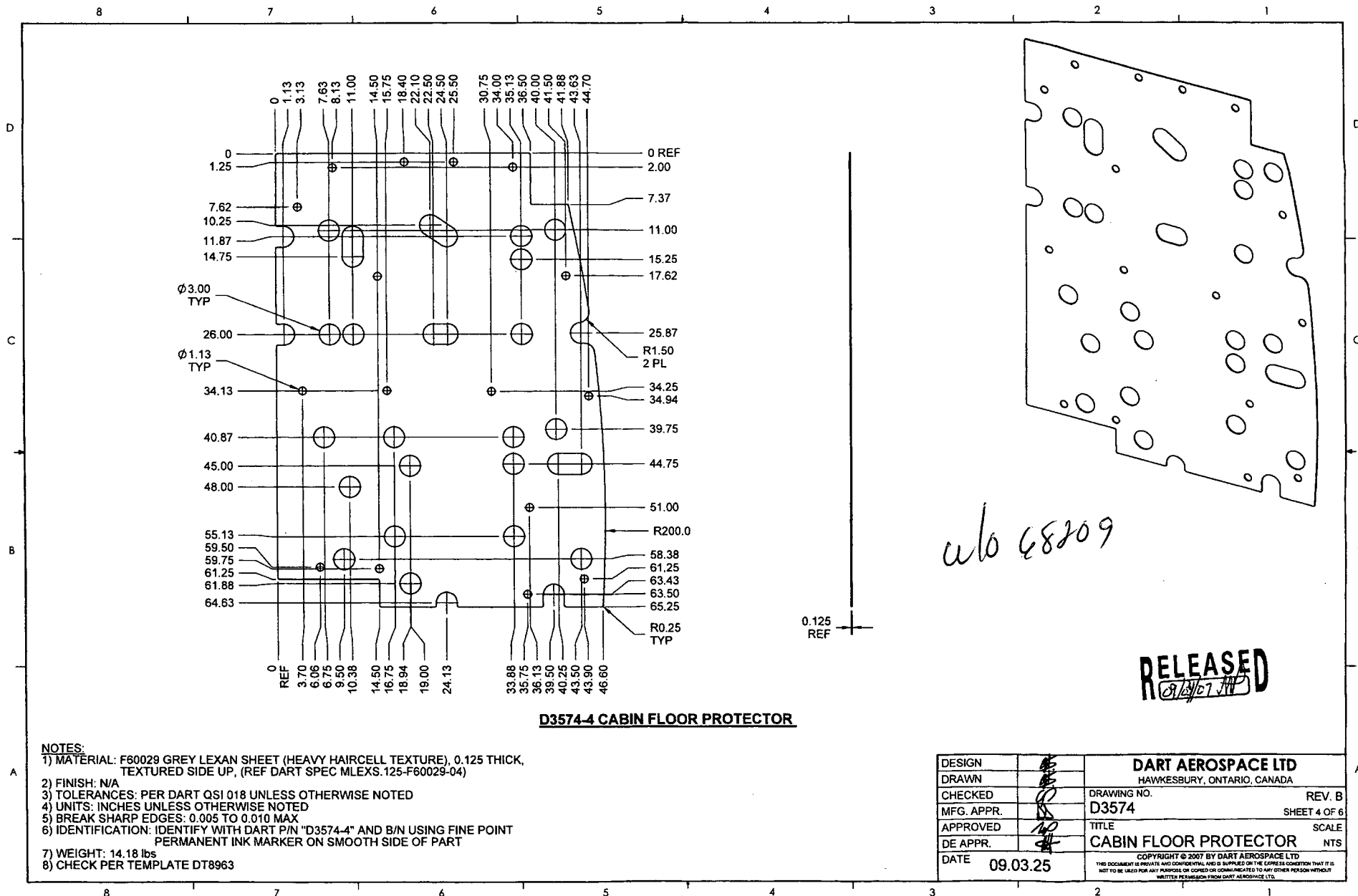
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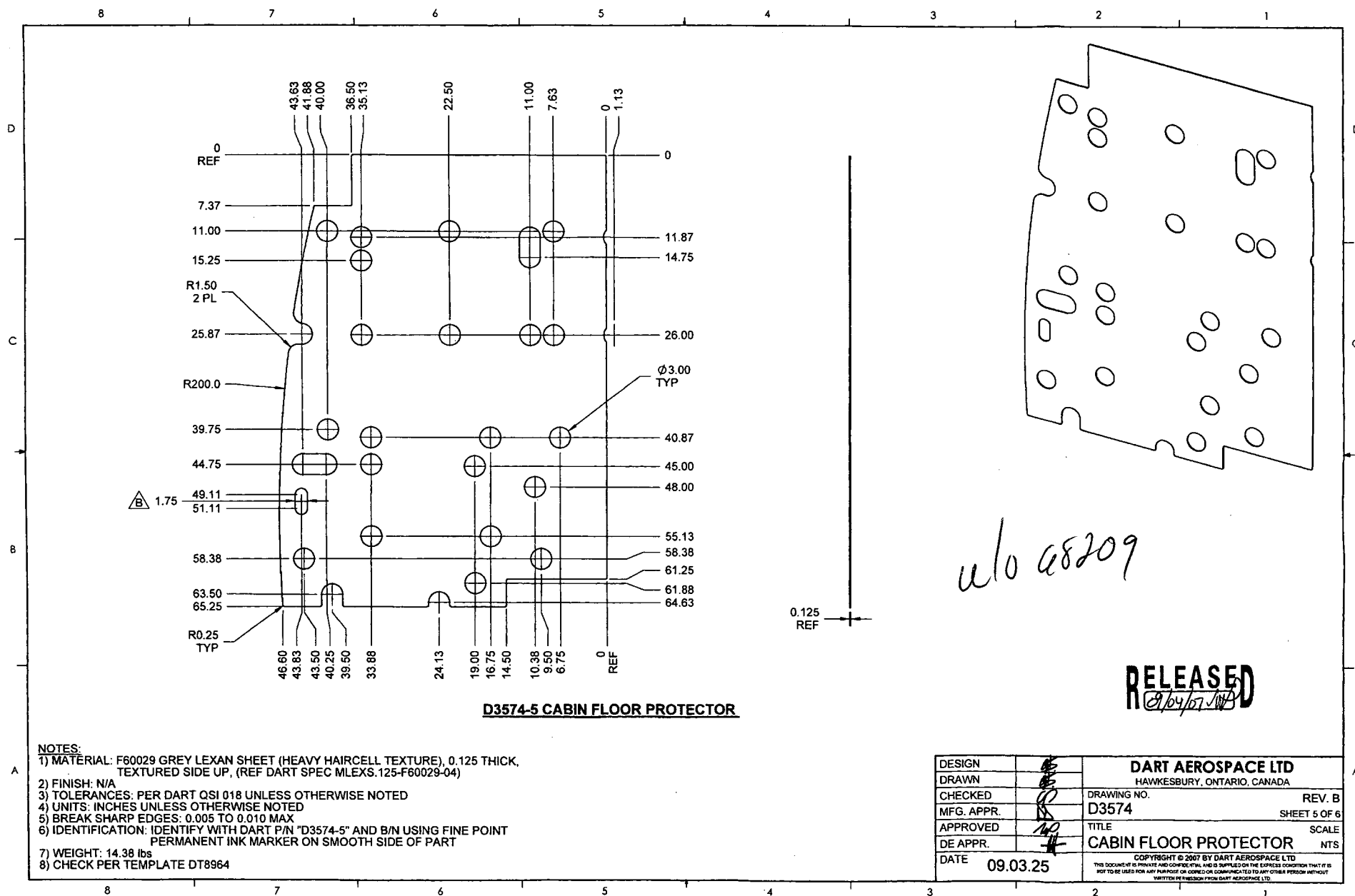
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